

5/26

DART AEROSPACE LTD	Work Order:	23507
Description: Window Frame	Part Number:	D2956
Drawing: D2956 Rev. C	Qty:	50

Stack of 20 RF 03.02.25

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	HF	05.06.06	50
2	METAL PG	Cut blanks as per template DT8447 Material: 5052-H34 sheet 0.040" thick. Issue PO for D2956	PO	2008/71	U 05.06.07 50
3	HAAS RL	Machine as per folio FA036 Recon & inspect for transit damage	CD	05/06/09	50
4	QC 6	Inspect Level 6	2	05.07.04	50
5	METAL	Deburr if applicable	MM	05/07/07	50
6	METAL	Acid etch & Alodine	FF	05.07.07	50
7	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	FC	0507P	50
8	QC	Inspect Level 3	CD	05/08/03	50
9	STORES	Identify and stock	CD	05/08/03	50
10	EXPEDITING	Close W/O Cost / part Z7.86 Z7.86	SAC 05/08/09 (50) inspect Level 21	CD	05/08/09 50

Rev	Date	Change	Revised By	Approved
A	00.02.11	New Issue	EC	
B	00.03.07	Now goes on Haas	EC	
C	00.05.08	Removed P/O for powder coating, added acid etch step	EC	
D	01.06.14	Updated dwg to rev.C	EC	EC

UNDER REVIEW

RF 03.02.21

RELEASED

EC 01.06.14

INCORPORATED INTO
D350-567-025

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 05/08/04

NOTE: Date & initial all entries

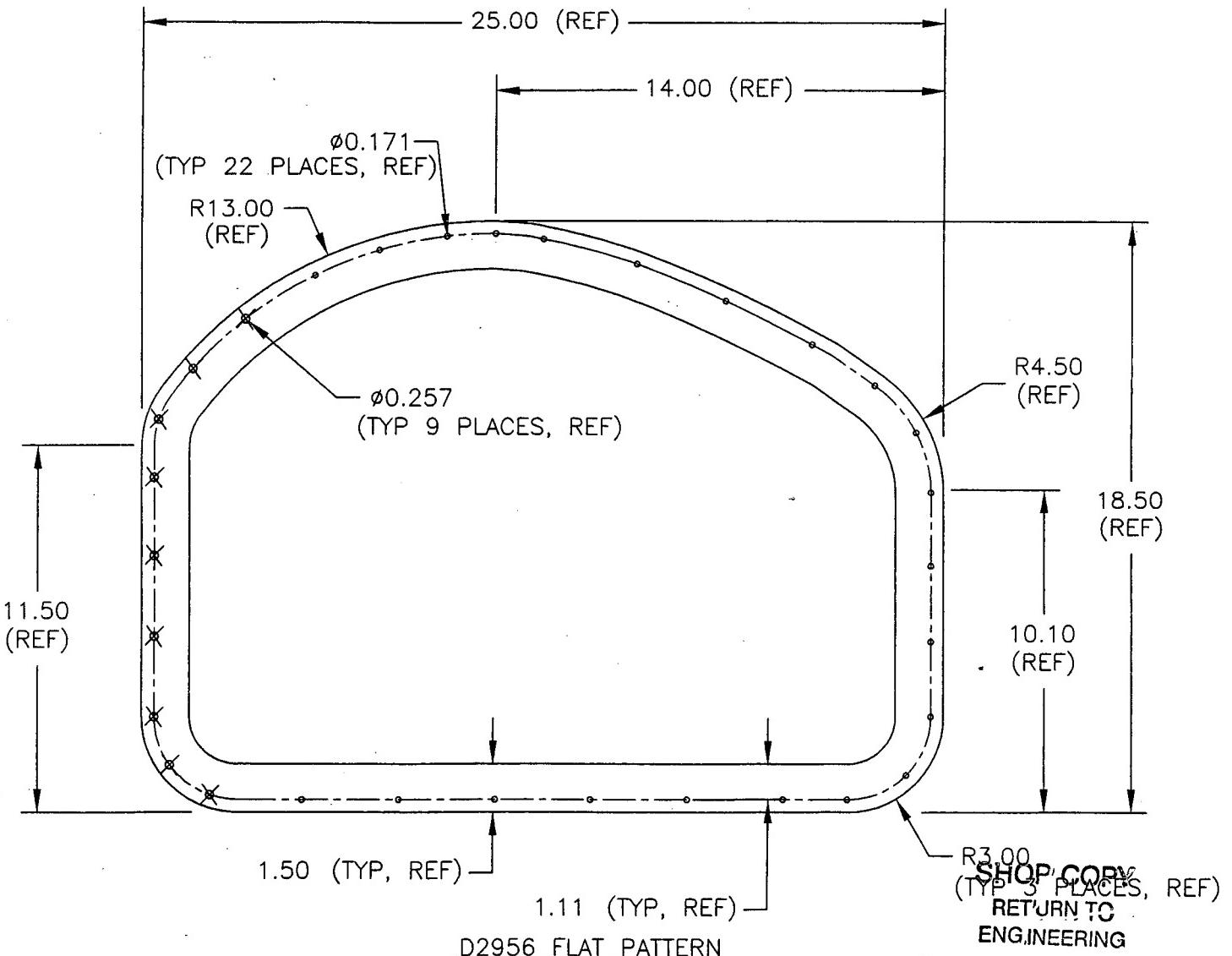
QA: N/C Closed: _____

Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2956	REV. C SHEET 1 OF 1
DATE 01.06.04		TITLE WINDOW FRAME	SCALE 1:5
A	00.01.20	NEW ISSUE	
B	00.02.23	Ø0.141 HOLES WERE Ø0.128 (NCR 407)	
C	01.06.04	REMOVE Ø0.141 HOLES	

RELEASED
01.06.05 *CH*



MACHINE PER DRAWING FILE "D2956-C1.DWG"

CHECK HOLES PER TEMPLATE DT8437

BEND PER TEMPLATE DT8567

MATERIAL: 5052-H34 (QQ-A-250/8) SHEET 0.040 THICK

FINISH: POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23507

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Job Costing Report

Dart Aerospace Ltd.
HawkesburyJun 06, 2005
11:47 am

Work Order No : 0023507
 Project Name : D2956
 Project For : WK526
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2956
 Description : Window Frame
 Manufactured : Yes
 Amount Req'd : 50
 Amount Done : 0
 Start Date : 06-06-05
 Est Finish Date : 06-30-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas[®] Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **1** OUR JOB NO **J0129149** SHIPPING MEMO **0307959**

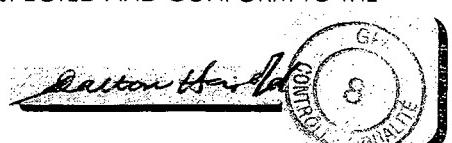
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	50 PCS	2008171	D2956	C	WINDOW FRAM	C
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
AL 5052-H32		CORUS ALUMINUM			1388651 ATT'D	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **27 JUNE 2005**

G.F.I. Q.C. REP.





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ –LETTER OF COMPLIANCE

Date: 20 JUIN 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058953 # de commande SSMQ: 842342
Customer's order #: SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
4	9	.040" X 48" X 96"	5052 H32		1388651

Bien à vous,
Yours truly,

Jean Raymond

Commis à l'administration.
Administration Clerk.



DOC : V/0080134390

DATE : 2004-11-19

PROD. REF. : 0000166327

NR : 50914/01

PAGE : 1 / 1
INSPECTION CERTIFICATE

Corus Aluminium NV.
A. Stockstraat 67, 2570 Oudel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 21 94

DESCRIPTION : ALU SHEET 5052-H32 QQA-250/8 AMS 4016 ASTM B209
DIMENSIONS : 96" X 48" X 0.04"
ARTICLE NO. :

CUSTOMER : CORUS ALUMINIUM ROLLED PRODUCTS US
475 N. MARTINGALE ROAD, SUITE 400
SCHAUMBURG 60173 USA

YOUR ORDER NUMBER : PO2731 (SAMUEL'S PO# A15790)
OUR ORDER NUMBER : 50914/01
DOCUMENT NUMBER : V/0080134390

COIL NUMBER CAST NUMBER CHEMICAL COMPOSITION (%)

	COIL NUMBER	CAST NUMBER	Si	P	Cu	Mn	Mg	Cr	Zn
			MIN	MAX	MIN	MAX	MIN	MAX	MIN
002	1388651		0,12	0,40	0,10	0,10	2,2 2,8	0,15 0,35	0,10

OTHERS : EACH : MIN MAX
TOTAL : MIN MAX

TEST-NUMBER MECHANICAL PROPERTIES
 1 N/MM² = 1 MPa = 0,1 MPBAR = 0,102 KG/MM² = 0,145 KSI
 /A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

	TEST-NUMBER	RM KSI	RP02 KSI	A S		
					MIN	MAX
002	/M	33	29	10		

1) 282443
1. 444
1. 445

HEAD OF LABORATORY,
XAVIER SCHELTJENS

Corus Aluminium Rolled Products - Corus Aluminium Extrusions